Date: Wednesday, 1/23/2008 11:35:53 AM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: MIRROR BRACKET
Job Number	: 36919			
Estimate Number	: 10142			
P.O. Number	:		Part Number	: D2161204
This Issue	: 1/23/2008	S.O. No. :	Drawing Number	: D2161 REV B2
Prsht Rev.	: NC		Project Number	: N/A
First Issue	: / /	Type : SMALL /MED FAB	Drawing Revision	: B2
Previous Run	: 36886		Material	:
Written By	:		Due Date	: 1/30/2008 Qty: 5 Um: Each

Checked & Approved By : *XX 08 01 23*
Comment : Est Rev:A New Issue 05-11-01 JLM

Additional Product

Job Number:

Seq. #:	Machine Or Operation:	Description :		
1.0	36919A *D2013-5*	*FC 08 02 21*		*(4)*
2.0	36919B *D2013-6*	*FC 08 02 21*		*(4)*
3.0	36919C *D2037-101*	*FC 08 0221*		*(4)*
4.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1		

Comment: LARGE FABRICATION RESOURCE 1

1-Assemble on Jig DT8065 as per Dwg D2161 *FC* *08 /02/21 (4)*

2-Weld as per Dwg D2161Identify as D2161-204 *FC*

Seq. #:	Machine Or Operation:	Description :
5.0	DO NOT USE	WELD INSPECTION

QCS: →   *QCS 08/02/22 (4)*

Comment: WELD INSPECTION   *QC9 ⇒ PD 08-02-21 (4)*

6.0	POWDER COATING	POWDER COATING

M 100 700

Comment: POWDER COATING
Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3   *08-02-25*

7.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION

(4)

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION   *M.A 07/02/25*

8.0	QC21	FINAL INSPECTION/W/O RELEASE

(4)

Comment: FINAL INSPECTION/W/O RELEASE   *08/02/25*

Job Completion   *2008/2/25 (4)*

Form: rprocess

Dart Aerospace Ltd

WORK ORDER CHANGES

W/O:							
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes / No DQA: ⟨A⟩ Date: 08.02.26

QA: N/C Closed: _____ Date: _____

WORK ORDER NON-CONFORMANCE (NCR)

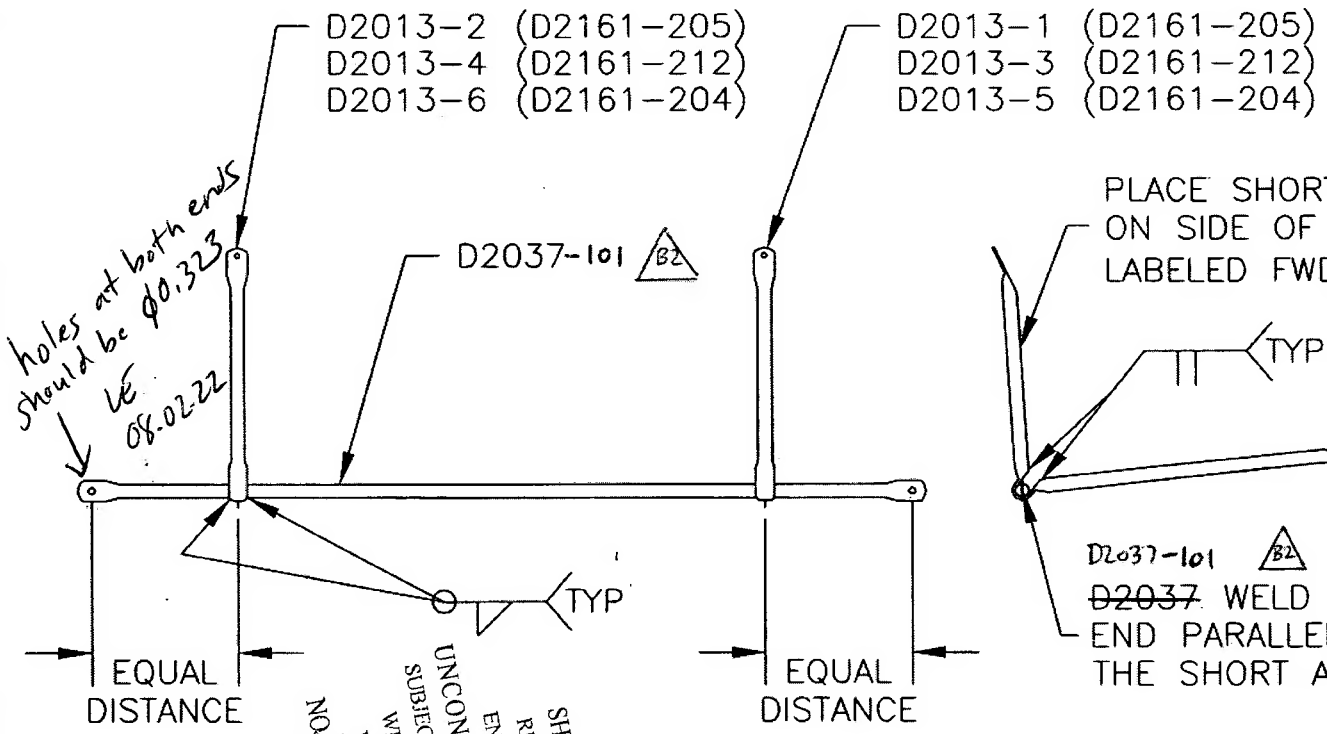| NCR:			Corrective Action — Section B					
DATE	**STEP**	**Description of NC** Section A	**Initial** Chief Eng	**Action Description** Chief Eng	**Sign & Date**	**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
08.02.22	4.0	D2037-101 hAs A⌀323 on one side only. Should be 2 ends.	LE 08.02.22	Drill open ⌀.257 →.323. As per hand change on Dwg.	FE 08/02/26	JB 08/02/22	LE 08.02.22	✓ 08.02.22

NOTE: Date & initial all entries

D2013-2 (D2161-205)
D2013-4 (D2161-212)
D2013-6 (D2161-204)

D2013-1 (D2161-205)
D2013-3 (D2161-212)
D2013-5 (D2161-204)

holes at both ends
should be ⌀0.323
LÉ
08.02.22

D2037-101 /B2\

PLACE SHORTER ARM
ON SIDE OF JIG DT8065
LABELED FWD (TYP)

TYP

TYP

D2037-101 /B2\

~~D2037~~ WELD FLAT
END PARALLEL TO
THE SHORT ARM

EQUAL DISTANCE

EQUAL DISTANCE

NOTE: WELD ASSEMBLY
USING JIG DT8065

FINISH: ~~POWDER COAT ASSEMBLY BLACK CRINKLE (4.3.5.3) PER DART QSI 005 4.3~~
POWDER COAT BLACK SANDTEX (4.3.5.7) PER
DART QSI 005 4.3 /3\

DETAIL OF D2161-204
DETAIL OF D2161-205
DETAIL OF D2161-212

RELEASED
LÉ 99.06.10

		DESIGN	JB		DART AEROSPACE LTD		
					HAWKESBURY, ONTARIO, CANADA		
		CHECKED	LÉ	DRAWN BY			
		APPROVED	RT	DRAWING NO. D2161		REV. B	
				TITLE MIRROR BRACKET		SHEET 1 OF 1	
	DATE 99.06.07						SCALE NTS
A	93.04.29	NEW ISSUE					
B	99.06.07	REDRAWN FOR CLARITY ADDED -204/-205/-212 DESIGNATIONS					
B1	02.03.25	CHANGE FINISH					
B2	02.06.14	D2037-101 w/D2037-101					